



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D5770-041**  
**Job Sheet 207406**



Part No: D5770-041

Job Qty: 2 pcs

Part Name: Attachment Hoop



Part Weight: 0 lbs

Job Created: 2/25/20

Due Date: 3/6/20

Type: Stock

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG D5770 REV.A IPP REV:A NEW ISSUE 20.01.14 JV VERF:DD

Ship Via:

**POSITIVE RECORD**

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

Priority: Medium

Placed by mistake  
NO 20.02.20

### Bill of Materials

### Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Conventional Mill - 1	2		3/6/20	0.25	0.67	Conventional Mill - 1		
		pcs					Conventional Mili - 2		
110	QC 2	2		3/6/20	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

**PRIORITY**



Container No: S259708



Part: D5770-041

Job No: 207406

Serial No/Batch: S259708

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Dart  
1270  
Hawkesbury  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dart.com  
www.dartaerospace.com

Date:

Plex 2/26/20 10:03 AM Dart.lajeunesse.marie

120 QC 5	2 pcs	3/6/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Large Fab - Welded Assy-1	2 pcs	3/6/20	0.00 1.00	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
140 QC 9	2 pcs	3/6/20	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
150 QC 5	2 pcs	3/6/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	

m/20/03/02

DAS  
24  
9-89DAS  
43  
9-89

					QC 5 - 3	DAC
					QC 5 - 43	43
					QC 5 - 49	9-89
					QC 5 - 51	
					QC 5 - 56	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	2 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	DAC
					Packaging 3 - 20 - B4B	43
					Packaging 3 - 21 - B4B	9-89
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
170	QC 21 - SA	2 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21	SA
					QC 21 - SA - 70	21
					QC 21 - SA - 53	53

Part Op 100 - 1-Start with D5770-5 hoop as stock. 2-Machine as per drawing see sheet 3 detail C. 3-Deburr

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - 1-Attach two D5770-7 lugs to 11.000" spacing jig DT using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 1. Centre as per view A-A sheet 1. 2-Weld as per sheet 1. A/R 4430 rod Batch: 137070

140 - QC9- Inspect visual per QSI004- Fusion Welds

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location: \_\_\_\_\_, See note 6.  
170 - QC21- Final Inspection - Work Order Release

**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
D5770-5	Hoop	2 pcs (1 ea)	100-Conventional Mill - 1	S259556-1
D5770-7	Lug	4 pcs (2 ea)	130-Large Fab - Welded Assy-1	S259494

**Job Allocations**

Operation	Component Part	Required	Inventory	Allocated
100-Conventional Mill - 1	D5770-5	2	0	0
130-Large Fab - Welded Assy-1	D5770-7	4	0	0

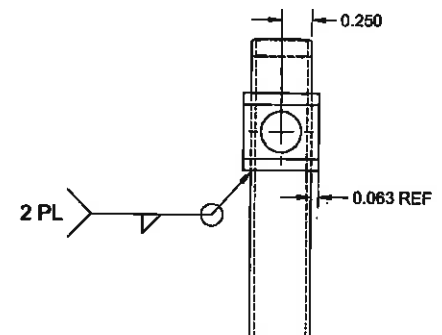
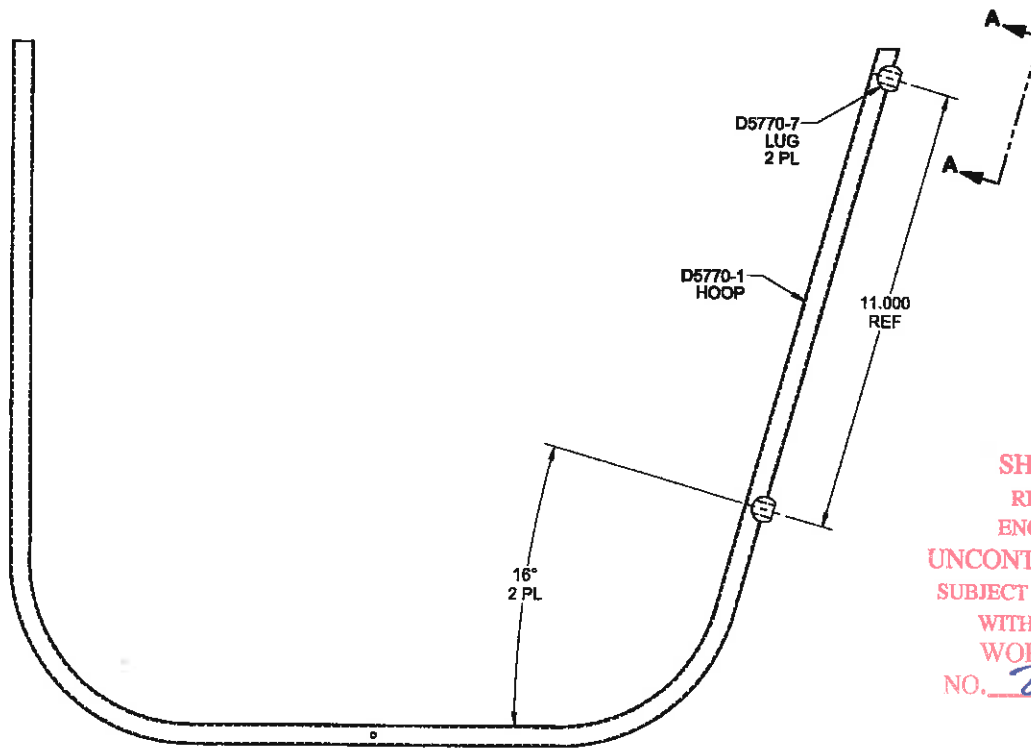
**Part Specifications**

Specifications could not be found.

Plex 2/26/20 10:03 AM Dart.lajeunesse.marie



QTY -041	P/N	DESCRIPTION
X	D5770-041	ATTACHMENT HOOP
1	D5770-1	HOOP
2	D5770-7	LUG



VIEW A-A  
SCALE 3X, 2 PL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 207406 MJS  
2002-26

**D5770-041 ATTACHMENT HOOP**  
(DERIVED FROM AERO DESIGN P/N 76422-01)

UNDER REVIEW  
URF 2020-522 20.02.14 (NO)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
  - 7) WEIGHT: 0.91 lbs
  - 8) WELD PER DART QSI 004

RELEASED

2020 FEB 18 NO  
ECN 2020-521

APPROVED

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	ZF	20.01.09
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.09		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5770

TITLE

BASKET HOOPS

REV. A

SHEET 1 OF 7

SCALE

NTS

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
<b>Root Cause</b>  <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		<b>FAULT CATEGORY</b>  <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>			
Other/Details:					